

Work Order ID 53348

November 2, 2009 10:41:14 AM

Blue



Page 1

Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:Approvals: Process Plan: *P*

Date: 02/11/2 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2892	Rev A

100



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo 0.00

HAAS CNC vertical machine #1

Machine as per Folio FA082 Tumble & Deburr

MWF
02/11/09
12 *0*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

MWF
02/11/09
12 *0*

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

DSR
02/11/09
12 *0*

Work Order ID 53348

Page 2

November 2, 2009 10:41:14 AM

Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125



Spray Painting per QSI005 4.2

0.00

m 09 11 15 (12)

SprayPaint

Memo

0.00

Spray Painting

Prime B110199

Spray Paintat Delfleet Blue B113171

Clear Delfleet B113088

135



QC14- Inspect Spray Paint

0.00

ZT 09 - 11 - 16

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: *X-tables*

0.00

M 09 11 16 (12)

Packaging

Paint

Memo

0.00

Packaging

Work Order ID 53348

Page 3

November 2, 2009 10:41:14 AM

Item ID: D2892-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

09/11/16

QC

Memo

0.00

Quality Control

MF
09-11-16

Picklist Print

Page 1

November 2, 2009 10:41:18 AM

Work Order ID: 53348



Parent Item: D2892-1RevA



Parent Item Name: Support

Start Date: 02/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK077RevA		Manufactured		No		110	Each	17.0000	6.0000			

D2892-1 TURNING DETAIL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

17

42245

4

43386

6

43869

7

mmw
09/11/03

6

DART AEROSPACE LTD	Work Order:	5334/8
Description: Ø2.500 Support	Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.130	.130	.131	.130	.130
AB	0.290	0.310		.308	.306	.306	.300	.305
AC	0.040	0.060		.050	.047	.050	.050	.047
AD	0.115	0.135		.126	.126	.125	.125	.124
AE	0.240	0.260		.251	.251	.252	.248	.250
AF	0.188	0.193		.191	.191	.190	.190	.190
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.144	1.144	1.143	1.144	1.143
AI	0.454	0.474		.454	.454	.463	.462	.460
AJ	0.240	0.260		.250	.250	.250	.250	.25
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.259	.259	.258	.258	.258
AM	1.663	1.683		1.664	1.665	1.667	1.675	1.677
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.783	2.783	2.785	2.785	2.783
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: MW Date: 09/11/02

Audited by: DSJ Date: 09/11/05

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<u>JL</u>

DART AEROSPACE LTD	Work Order:	53348
Description: 82-500 Support	Part Number:	2892-1
Inspection Dwg: 2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article **Prototype**

Measured by:	mjt
Date:	5/11/04

Audited by:	
Date:	09/11/05

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	53348
Description: Ø 2.500 Support	Part Number:	2892-1
Inspection Dwg: D2892 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance		11	12	Method of Inspection	Comments
	Min	Max				
A A	.115	.135	.131	.130		
A B	.290	.310	.310	.310		
A C	.040	.060	.052	.053		
A D	.115	.135	.125	.124		
A E	.240	.260	.247	.247		
A F	.188	.193	.190	.190		
A G	.240	.260	R.250	R.250		
A H	1.126	1.146	1.139	1.138		
A I	.454	.474	.463	.463		
A J	.240	.260	R.250	R.250		
A K	.053	.073	R.063	R.063		
A L	.257	.262	.258	.258		
A M	1.663	1.683	1.672	1.673		
A N	.053	.073	R.063	.063		
A O	.023	.042	R.032	R.032		
A P	2.779	2.789	2.783	2.783		

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A
Rev	Date	Change	Revised by
A		New Issue	KJ/JLM

ITEM NO.	QTY. -041	QTY. -042	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X				D2812-041	STEP WELDMENT
2		X			D2812-042	STEP WELDMENT
3			X		D2812-043	STEP ASSEMBLY
4				X	D2812-044	STEP ASSEMBLY
11	1	1	1	1	D2812-1	STEP
15	1				D2795-1	ARM
16		1			D2795-2	ARM
17			1		D2795-3	ARM
18				1	D2795-4	ARM
19	2				D2795-041	ARM ASSEMBLY
20		2			D2795-042	ARM ASSEMBLY
21			2		D2795-043	ARM ASSEMBLY
22				2	D2795-044	ARM ASSEMBLY
19	2	2	2	2	D2875	END PLATE
20		6	6		D3730-1	ANGLE
21			6	6	D3741-1	ANGLE
30		24	24		CR3213-5-4	RIVET
31		12	12		MS20470AD5-16	RIVET

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

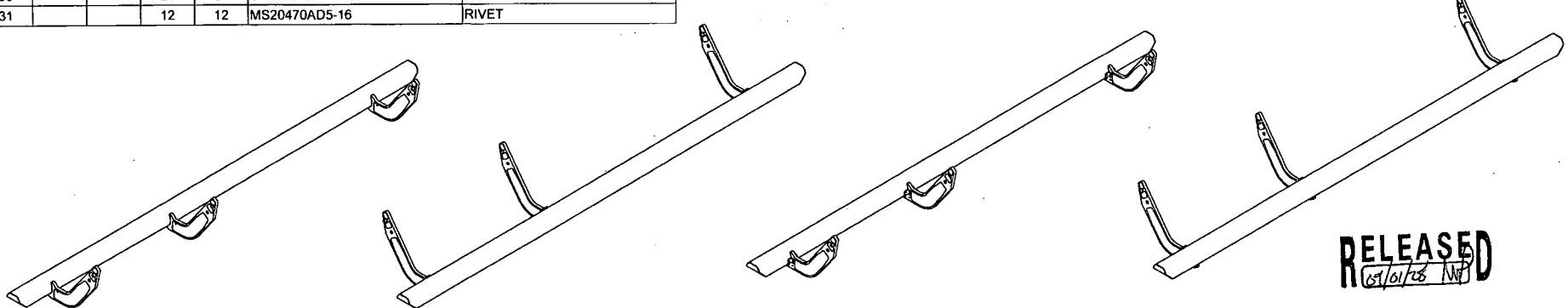
SUBJECT TO AMENDMENT

WHEN CHANGED

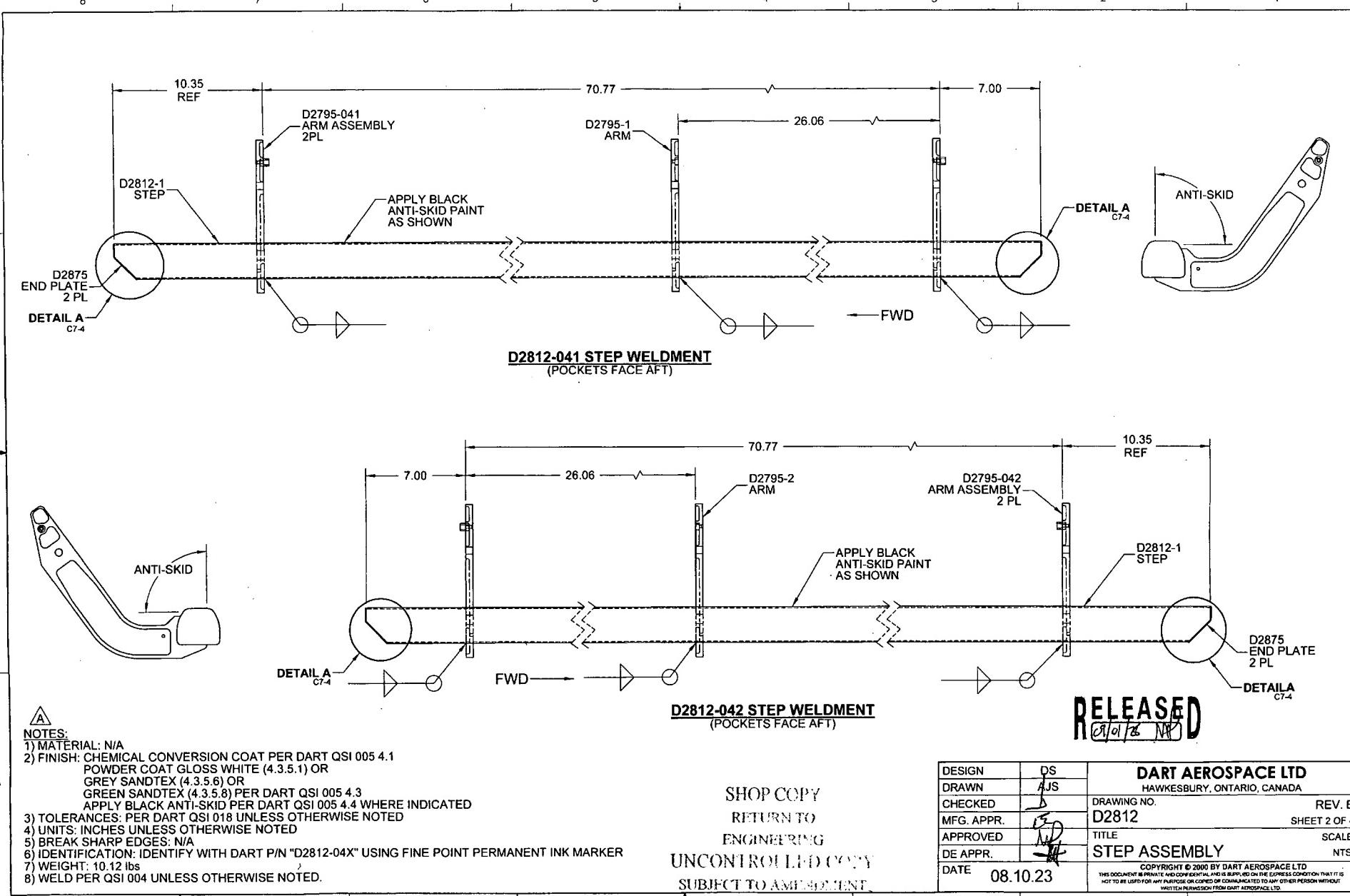
WORK CENTER

NO. 5334E

BP09-11-2

D2812-041 STEP WELDMENTD2812-042 STEP WELDMENTD2812-043 STEP ASSEMBLYD2812-044 STEP ASSEMBLY

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS -041 & -042 UNCHANGED. ADDED -043 & -044			AJS	08.10.23
A	NEW ISSUE			DS	00.11.03
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. B		
MFG. APPR.		D2812	SHEET 1 OF 4		
APPROVED		TITLE	SCALE		
DE APPR.		STEP ASSEMBLY	NTS		
DATE	08.10.23			COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

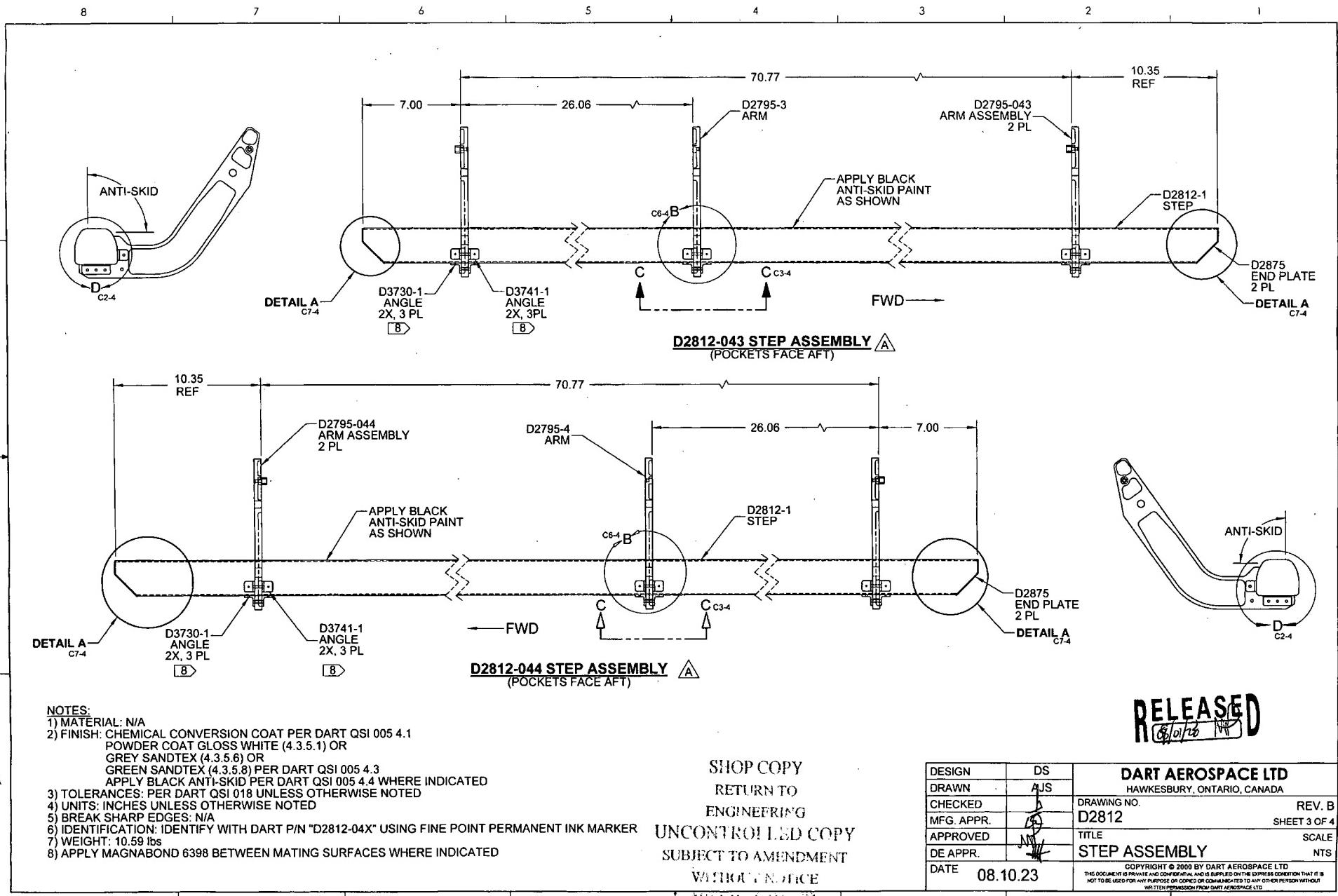


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK CLEAR
NO. 53344

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	DRAWING NO. D2812
CHECKED	<i>[Signature]</i>	REV. B SHEET 2 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE STEP ASSEMBLY
APPROVED	<i>[Signature]</i>	SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	08.10.23	

COPYRIGHT © 2000 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE IN THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) OR
GREY SANTEX (4.3.5.6) OR
GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PER DART QSI 005 4.4 WHERE INDICATED
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2812-04X" USING FINE POINT
- 7) WEIGHT: 10.59 lbs
- 8) APPLY MAGNABOND 6398 BETWEEN MATING SURFACES WHERE INDICATED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DESIGN	DS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>b</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>(S)</i>	D2812	SHEET 3 OF 4	
APPROVED	<i>MJ</i>	TITLE	SCALE	
DE APPR.	<i>(S)</i>	STEP ASSEMBLY	NTS	
DATE	08.10.23	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS		

COPYRIGHT © 2000 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT

